	(a)	
NCR:	(Yes) /	No

DQA:

Date:

NCR: (Yes)/ No WORK ORDER NON-CONFORMANCE / UPDATE																
													QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·	_
Nork Order:									AGAINST DEPARTMENT/PROCESS							
Part N	-						Rework Scrap	Skid-tube Crosstube Machining Small Fab					Water Jet J. Eng. Coor.	Engineering Quality		
NCR N	lo.			14			Use-as-is Work Order Update			noforming Large Fab	ı	Finishing omposite	Rec/Stor	e/Packaging Supplier	Other	
Root		·			Desc	rip	tion of work order update		nitial	ļ	Action		Sign &	· · · · · · · · · · · · · · · · · · ·		
Cause		Date	Step	Qty			r Non-conformance	Ch	ief Eng	De	scripti	on	Date	Verification	QC Inspector	\Box
oc/Data quip/Tooling		B-01-08	lla	1	hale	,	lin tectlo con			scrop	and	roplas	13-01-03	15 15 15 15 17 17		
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Lario		Bending			Γ	7	Bend		Grain				Ovalized	Г	Pressure/Forced	
		_	ot Concer	ntric to	o/s		BOM/Route	\vdash	Hardware				Over/Under	tolerance	Temperature/Cure	
						Broken/Damaged		1	ion Incomplete			Part Incorred	ļ	Weld		
		Crushed/0	Crimped.		F	\neg	Burrs		· ·	ions Incomplet		ear	Part Lost/Missing Wrong Stock			1
		Cuffs Contamination				Contamination		Mainte	enance	-		Part Moved				
	Heat Treat					Countersink		Mislabe	eled		. 8	Positioned V	Vrong			
		Inspection	n Strip in	Tube	Γ		Cut Too Short		Misread	t			Power Loss/	Surge	Other	
		Ripples in	Bend				Drill Holes		Offset							
		Torque W	aves in E	xtrusio	n [Drawing		Out of	Calibration						
		Turning S	equence				Finish		Out of :	Sequence						
	Wave/Twist in Tube					1	Folio		Outside	Dimensions						

Work Order ID 90548 *90548* Page 2 September-19-12 12:38:37 PM Item ID: D2037-101 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Arm *4* Start Qty: 4.00 **Start Date:** 9/19/12 **Cust Item ID:** Required Date: 10/05/12 **Req'd Qty:** 4.00 **Customer:** Reference: Run **Tooling:** Process Plan: _____ Date: ____ Approvals: Date: _____ Stop Date: SPC (Y/N): QC: Date: Operation Sequence ID/ Reject Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Code Qty Number Stamp **Run Hours Qty** Identify as per dwg & Stock Location: W/A OO 130 0.00 *130* 4 8 13-1-3 0.00 Packaging Memo Packaging

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

QC

140

Quality Control

W 1301.03

	•										DQA	: Date	:
NCR: Y	es /	No				WORK ORDER NO	ON-CO	ONFORM	MANCE / UP	DATE			
								<u> </u>			QA Closed	l: Date	:
Work Orde	ar.					DISPOSITION				AGAINST D	DEPARTMEN	T/PROCESS	
WOIK Olde						Rewo	rk□		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.		٠			Scra	-	1	Machining	Small Fab	Pr	od. Eng. Coor.	Quality
			,			Use-as-	-is	Thern	noforming	Finishing	Rec/St	ore/Packaging	Other
NCR N	No					Work Order Upda	te		Large Fab	Composite [Supplier	
Root	T				Descri	ption of work order upd	ate.	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance		Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data							^						
Equip/Tooling							·						
Operator	Ш												
Material		-											
Setup													
Other													
Process	Ш						1						
Supplier	Ш			·									
Training	Ш												
Unapproved												_	
							FA	ULT CATE	GORY				
Landi	ng Ge					General	-			_		_	_
		ending				Bend	ļ	Grain		-	Ovalized		Pressure/Forced
			t Concer	ntric to (o/s	BOM/Route		Hardwa		<u> </u>	─ ┤ '	er tolerance	Temperature/Cure
	—	acks				Broken/Damaged	1		ion Incomplete	ļ	Part Incor	} −	Weld
	—		Crimped.		<u></u>	Burrs			tions Incomplete/	Unclear	Part Lost/	- <u>-</u>	Wrong Stock Pulled
	\vdash	uffs				Contamination		Mainte			Part Move		
	L. H	eat Trea	t			Countersink		Mislabe	eled		Positioned	l Wrong	 .
	In	spectio	n Strip in	Tube		Cut Too Short		Misrea	d	[Power Los	s/Surge	Other
	l IRi	nnles in	Rend		1	Drill Holes	i	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

September-19-12 12:38:37 PM

Work Order ID:

90548

Parent Item:

D2037-101

Parent Item Name:

Arm

Start Date: 9/19/12

Required Date: 10/05/12

Start Qty: 4.00

Required Qty: 4.00

Comments:

I

IPP Rev:A New Issue 05-11-01 JLM

IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No		NAME OF BUILDING	110	f	639.1204	3.916	16.488421			
304 RD Tube .750 x .049W	7									z	(4)) FX	F12-10-22
•				Location		Loc Qty	<u>Lo</u>	oc Code				•	
		-		MAT017		639.120417							
				109	9314	9.333							
				111	1619	3			-				
				112	2187	4							
				112	2800	11							
				114	4852	2.75							
				116	5108	3							
				117	7797	0.75							
,				120	0441	0.000794							
				121	1170	234.89							
				121	1666	10.232					SF	12	\ 1 \
				122	2312	87.19			_ 4 ,	1221	Ø '	12-17	2- Uf
					2468	272.974623			16	.4804			•

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-C	ON	NFORN	MANCE / UPDATE		QA Closed:	Date	·
						DISPOSITION			ACAIN	ST DE	PARTMENT		
Work Orde	er:					DISPOSITION			AGAIN	31 06	PARTIVICIVI)	PROCESS	
Part No.				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR I	No.					· Work Order Update	^j	-	Large Fab Composi	ite[Supplier	
Root					Descri	ption of work order update	l li	nitial	Action		Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
опарриотеа	لــــا		<u> </u>		1	· F/	AUL	T CATE	GORY			<u> </u>	
Landi	ng G	Gear				General							
		Bending Centre No	ot Concei	ntric to	o/s	Bend BOM/Route	-	Grain Hardwa	re		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
		Cracks				Broken/Damaged	Ш	Inspecti	on Incomplete	L	Part Incorre	ct _	Weld
	-	Crushed/	Crimped.			Burrs		4	ions Incomplete/Unclear		Part Lost/M	íssing	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte	nance		Part Moved		
	Ш	Heat Trea	it			Countersink		Mislabe	led		Positioned \	Wrong	******
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	/Surge	Other
		Ripples in	Bend			Drill Holes		Offset	4				

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

D2037-101 ARM

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. <u>90548</u> MLJ 12-09-20

D	FORMA "SQUAF FOR FU INDICA"	INCORPORATED C.1 C2 & C2. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS, ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A. NOW INDICATED AS 2 PL. REASON FOR CHANGE: UPPORDUCTION REQUEST.									
С	REDRA	WN, 0.386 W	RF	99.06.07							
В	-103 DE	LETED	JB .	93.04.20							
Α	NEW IS	SUE	JB	91,10.22							
REV.			DESCRIPTION	BY	DATE						
DESIGN		JB	DART AEROSPA	CELI	מו						
DRAWN		AJS	HAWKESBURY, ONTARK								

CHECKED REV. D D2037 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE DE APPR. ARM DATE

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NOTES:
1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, Ø0.750 x 0.049 WALL REF. DART SPEC M304TR0.750W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.50 lbs
8) FOR FURTHER INFO SEE DRAWING D2638.